

Work Order ID 84882

84882

Page 1

May-29-12 1:01:53 PM

Item ID: D209-669-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12/05/30 Tooling:

Date:

Run Start ***NR1***

QC:

Date: 12/05/30 SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D209-669-013 | Rev B | | | | | | | | |
| DSI 9450 | Rev A | | | | | | | | |
| 100 | DOCUMENT CONTROL | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| DC | Memo | 0.00 | | | | | | | |
| Document Control | Photocopy bluefile & type labels per PPP d209-669-013 CHG803 | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

84922

16

per ECN 12-599 h

for MLS 12-7-11

IX 12-7-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 84882

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Page 2

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Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 29/05/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
16
8-8 17/6/17

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-013

Location:

SHIP

12/27/17

140

0.00

140

QC

Memo

0.00

Quality Control

QC21- Final Inspection - Work Order Release

12/17/18

ME

12-07-18

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-29-12 1:01:56 PM

Page 1

Work Order ID: 84882

84882

Parent Item: D209-669-013

D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: New IPP 08.02.13 LL, verified by:DD
IPP Rev:B 08-05-20 chg QTY of D2570 DD verified by:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D209-669-043

Manufactured No

110

Each

2.0000

1

1

D209-669-043

Replacement Skidtube

**

84922

Location

Loc Qty

Loc Code

Mezz

2

39205

1

39206

1

D2917-1

Manufactured No

110

Each

0.0000

2

D2917-1

Saddle LH

**

2 B84937

D2918-1

Manufactured No

110

Each

3.0000

2

D2918-1

Saddle LH

**

2 84938

Location

Loc Qty

Loc Code

ST424

3

54467

3

AN4-51A

Purchased No

110

Each

302.0000

8

8

AN4-51A

Bolt

**

809 12-7-11

Location

Loc Qty

Loc Code

362

200

121181

200

ST361

102

119798

30

121584

72

Ex

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

May-29-12 1:01:56 PM

Page 2

Work Order ID: 84882

84882

Parent Item: D209-669-013

D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2570

Manufactured No

110

Each

711.0000

24

24

D2570

Bushing

**

B85411

Location

Loc Qty

Loc Code

ST011

711

72960

41

78586

9

79493

12

81956

24

81957

400

82874

225

MS21042L4

Purchased

No

110

Each

4,095.000

24

24

MS21042L 4

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

4095

119075

125

121011

713

121444

2957

121652

300

AN5-36A

Purchased

No

110

Each

184.0000

4

4

AN5-36A

Bolt

**

SP

Location

Loc Qty

Loc Code

340

134

121181

34

121652

100

ST340

50

121708

50

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

8

8

AN960.ID516

Washer

**

m119546 SP

May-29-12 1:01:57 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Picklist Print

May-29-12 1:01:57 PM

Page 3

Work Order ID: 84882

84882

Parent Item: D209-669-013

D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

1,447.000

4

4

MS21042L5

Nut

**

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

947

108827

8

116105

5

116548

43

117611

18

119109

865

17651

8

AN4-7A

Purchased

No

110

Each

124.0000

16

16

AN4-7A

Bolt

**

Location

Loc Qty

Loc Code

ST356

124

117514

24

120770

100

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

32

32

AN960JD416

Washer

**

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-29-12 1:01:57 PM

Page 4

Work Order ID: 84882

84882

Parent Item: D209-669-013

D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2929

Manufactured No

110 Each

86.0000

2

2

D2929

Spacer

**

Sp. 

Location

Loc Qty

Loc Code

ST021

86

53564

86

2x

D2930

Manufactured No

110 Each

102.0000

2

2

D2930

Spacer

**

Sp. 

Location

Loc Qty

Loc Code

ST021

102

53563

102

2x

D3405-041

Manufactured No

110 Each

6.0000

1

1

D3405-041

Lug Assembly

**

BSS450 12-7-17

Location

Loc Qty

Loc Code

ST478

6

62227

2

77000

2

82031

1

82032

1

AN4C47A

Purchased No

110 Each

48.0000


4

4

AN4C47A

Bolt

**

m122201 Sp 12-7-11 

Location

Loc Qty

Loc Code

ST361

48

118451

6

119798

2

121009

22

121585

18

May-29-12 1:01:57 PM

Shop Packet Print

Page 4

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-29-12 1:01:57 PM

Page 5

Work Order ID: 84882

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

84882

D209-669-013

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,346.000

5

5

MS21043-4

Nut

**

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1306

119546

147

121162

659

121652

500

D3405-043

Manufactured

No

110

Each

2.0000

1

D3405-043

Lug Assembly

**

Location

Loc Qty

Loc Code

ST478

2

82038

2

D3407-041

Manufactured

No

110

Each

27.0000

1

D3407-041

Tow Ring

**

Location

Loc Qty

Loc Code

ST463

27

82067

6

82068

19

82108

2

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-29-12 1:01:57 PM

Page 6

Work Order ID: 84882

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

84882

D209-669-013

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

156.0000

1

1

**

SP

SP

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

149

80252

1

81876

48

83584

100

D3417-5

Manufactured No

110

Each

78.0000

2

2

**

lc

B84943

12-7-11

D3417-5

Washer

Location

Loc Qty

Loc Code

ST042

78

78842

28

83318

50

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

INSTRUCTIONS:

1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
- b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
- c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 84882 MJS
 12/05/30

| | | | |
|------------|-------------|--|--------------|
| A | NEW ISSUE | AJS | 09.02.24 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9450 | SHEET 1 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SKIDTUBE INSTALLATIONS | NTS |
| DATE | 09.02.24 | COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

5.0 PARTS LIST

| ITEM | QTY -011 | QTY -012 | QTY -013 | QTY -014 | QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-------------|-------------|--------------|--|
| | X | | | | | | D209-669-011 | SKIDTUBE INSTALLATION, LH (AH-1W/J) |
| | | X | | | | | D209-669-012 | SKIDTUBE INSTALLATION, RH (AH-1W/J) |
| | | | X | | | | D209-669-013 | SKIDTUBE INSTALLATION, LH (AH-1P/F/S) |
| | | | | X | | | D209-669-014 | SKIDTUBE INSTALLATION, RH (AH-1P/F/S) |
| | 1 | 1 | | | X | | D209-669-041 | REPLACEMENT SKIDTUBE (AH-1W/J) |
| | | | 1 | 1 | | X | D209-669-043 | REPLACEMENT SKIDTUBE (AH-1P/F/S) |

IS:

| | | | | | | | | |
|----|----|----|---|---|--|--|-----------|-------------------|
| 50 | 4 | 4 | 1 | 1 | | | D3405-041 | LUG ASSEMBLY |
| 51 | 8 | 8 | 4 | 4 | | | AN4C47A | BOLT |
| 52 | 16 | 16 | 8 | 8 | | | D2570 | BUSHING |
| 53 | 8 | 8 | 4 | 4 | | | MS21043-4 | NUT |
| 54 | | | 1 | 1 | | | D3405-043 | LUG ASSEMBLY |
| 60 | 1 | 1 | 1 | 1 | | | D3407-041 | TOW RING ASSEMBLY |
| 61 | 1 | 1 | 1 | 1 | | | D3456-1 | WASHER |
| 62 | 1 | 1 | 1 | 1 | | | MS21043-4 | NUT |
| 63 | 2 | 2 | 2 | 2 | | | D3417-5 | WASHER |

WAS:

| | | | | | | | | |
|----|----|----|---|---|--|--|-----------|--------------------|
| 50 | 4 | 4 | 1 | 1 | | | D2736-1 | GHW LUG |
| 51 | 8 | 8 | 4 | 4 | | | AN4-46A | BOLT |
| 52 | 16 | 16 | 8 | 8 | | | D2570 | BUSHING |
| 53 | 8 | 8 | 4 | 4 | | | MS21042L4 | NUT (OR MS21042-4) |
| 54 | | | 1 | 1 | | | D2736-3 | GHW LUG |
| 60 | 1 | 1 | 1 | 1 | | | D2968-041 | TOW RING |
| 61 | 1 | 1 | 1 | 1 | | | AN970-4 | WASHER |
| 62 | 1 | 1 | 1 | 1 | | | MS21042L4 | NUT (OR MS21042-4) |

| | | | |
|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9450 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SKIDTUBE INSTALLATIONS | NTS |
| DATE | 09.02.24 | COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small> | |

24882

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

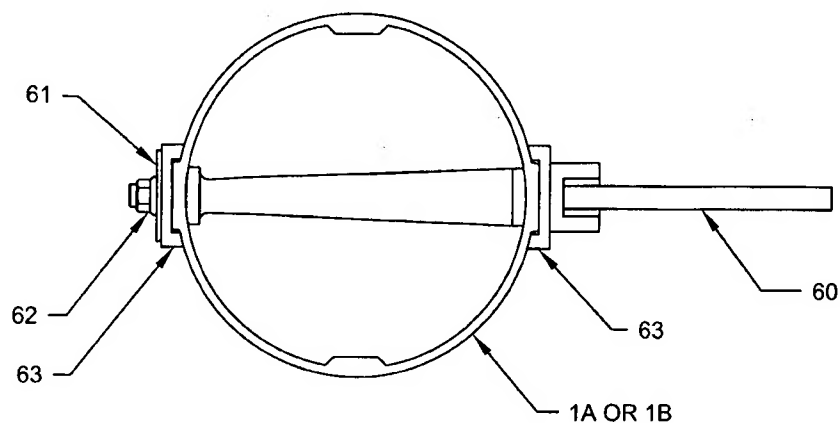
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

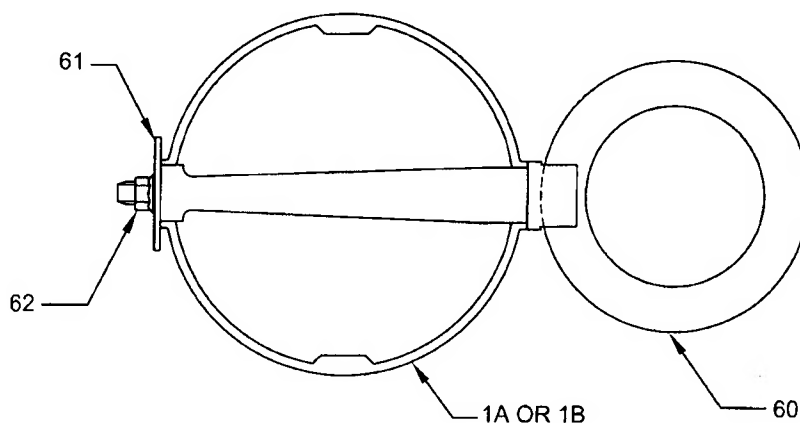
NOTE: Date & initial all entries

INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9450 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SKIDTUBE INSTALLATIONS | NTS |
| DATE | 09.02.24 | COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries